

Work Order ID 52937

October 19, 2009 11:03:00 AM



Page 1

Item ID: D3992-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PS

Date: 09/10/09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3992	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3992

Dwg Rev: *3*

Prog Rev: *1*

2-Deburr if necessary

B 9-10-08

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-10-08

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Page 2

Item ID: D3992-3

Accept

Setup Start

Revision ID: A

Stop

Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	⇒ 809/10/28			(46)	/		
130  Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00	80 09/11/04			6	/		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 809/11/05			(-3) (46)	/		

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Page 3

Item ID: D3992-3

Accept

Setup Start

Revision ID: A

Stop

Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

al 09/11/10

X6

0

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

mo 09/11/10

X6

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

alulio 06 SP

Work Order ID 52937

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Page 4

Item ID: D3992-3

Accept

Setup Start

Revision ID: A

Stop

Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00

Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:


Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/11/11
ME
09-11-10

Picklist Print

October 19, 2009 11:03:10 AM

Page 1

Work Order ID: 52937

Parent Item: D3992-3RevA-PRELIM

Parent Item Name: Reinforcement

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	284.9347	0.9735	1.5		



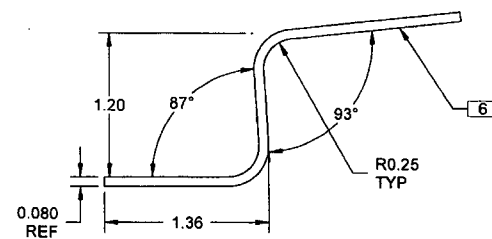
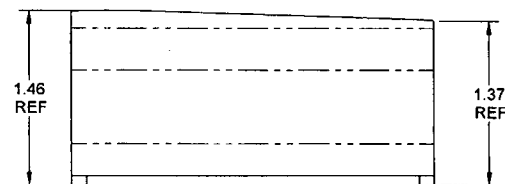
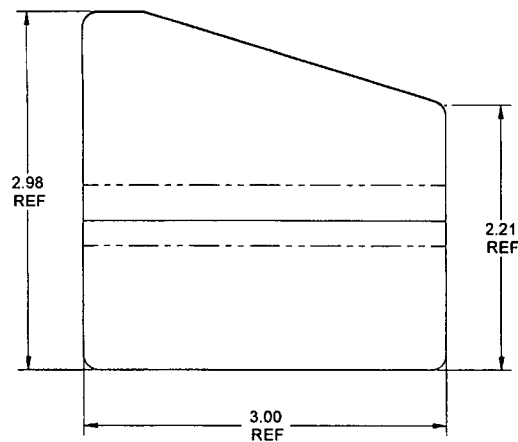
6061-T6 .080 Sheet



18 9-10-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	284.9347	
107904	0.02	
110254	2.5	
110630	38.0926	
112040	0.0437	
112141	33	
112512	19.2784	
112763	192	

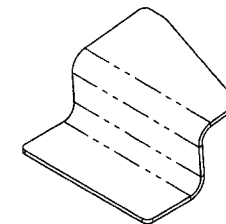
112763



D3992-1 REINFORCEMENT
MADE FROM D3992-1F

NOTES:

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs



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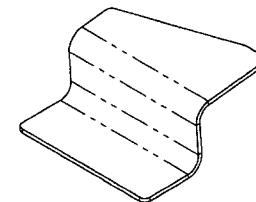
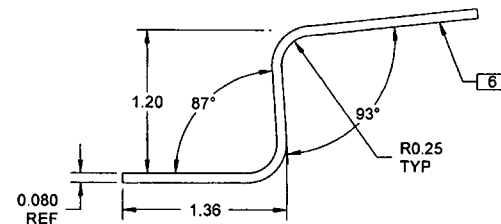
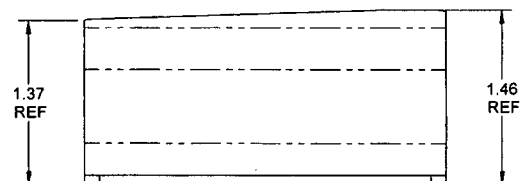
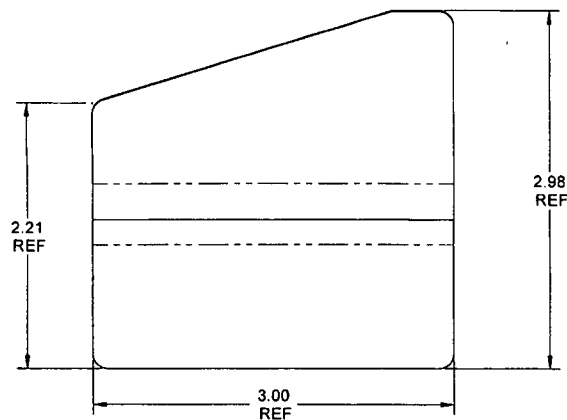
PL 09-10-19

RELEASE
2009-10-08

A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
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DATE	09.09.28		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
D3992		SHEET 1 OF 6
TITLE	REINFORCEMENT	SCALE
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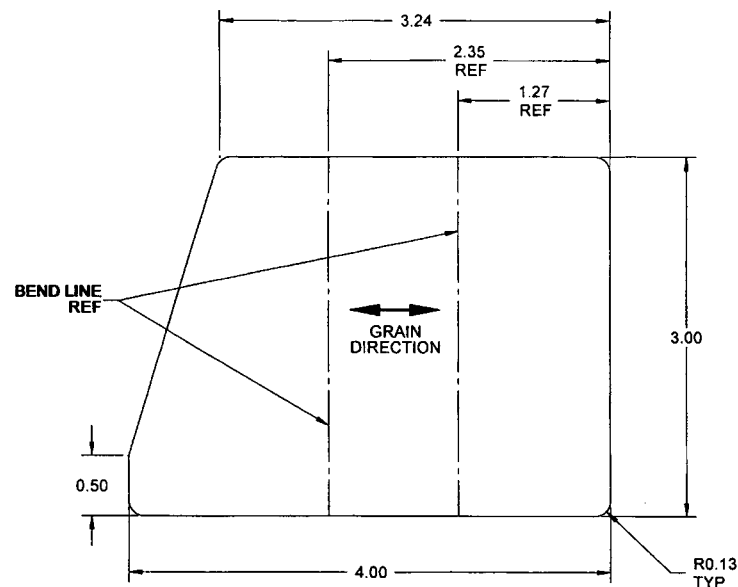
D3992-2 REINFORCEMENT
MADE FROM D3992-1F

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2009-10-08
JND

NOTES:

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN	<u>45</u>	DART AEROSPACE LTD	
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D3992-1F REINFORCEMENT FLAT PATTERN

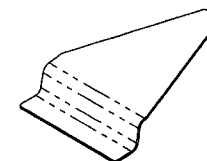
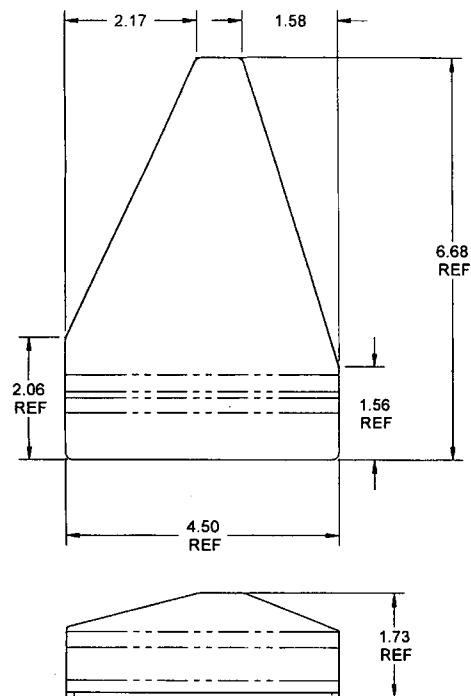
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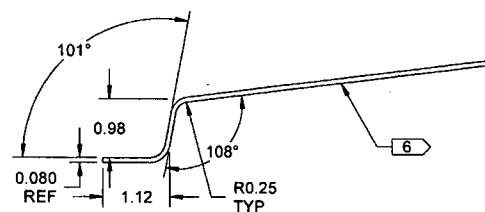
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

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DRAWN	<i>ES</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. A
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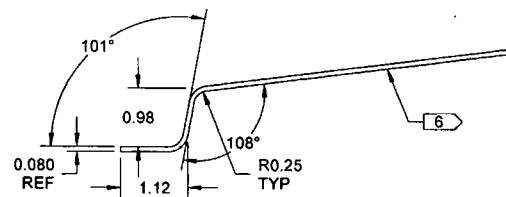
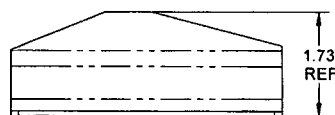
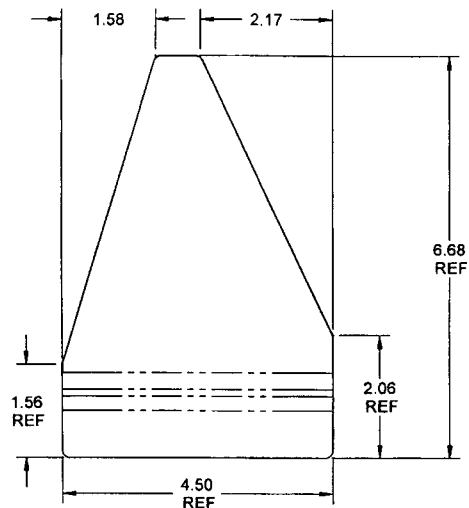
D3992-3 REINFORCEMENT
MADE FROM D3992-3F

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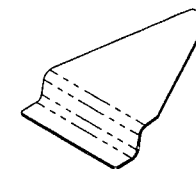
NOTES:

- 1) MATERIAL: MADE FROM D3992-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
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D3992-4 REINFORCEMENT
MADE FROM D3992-3F



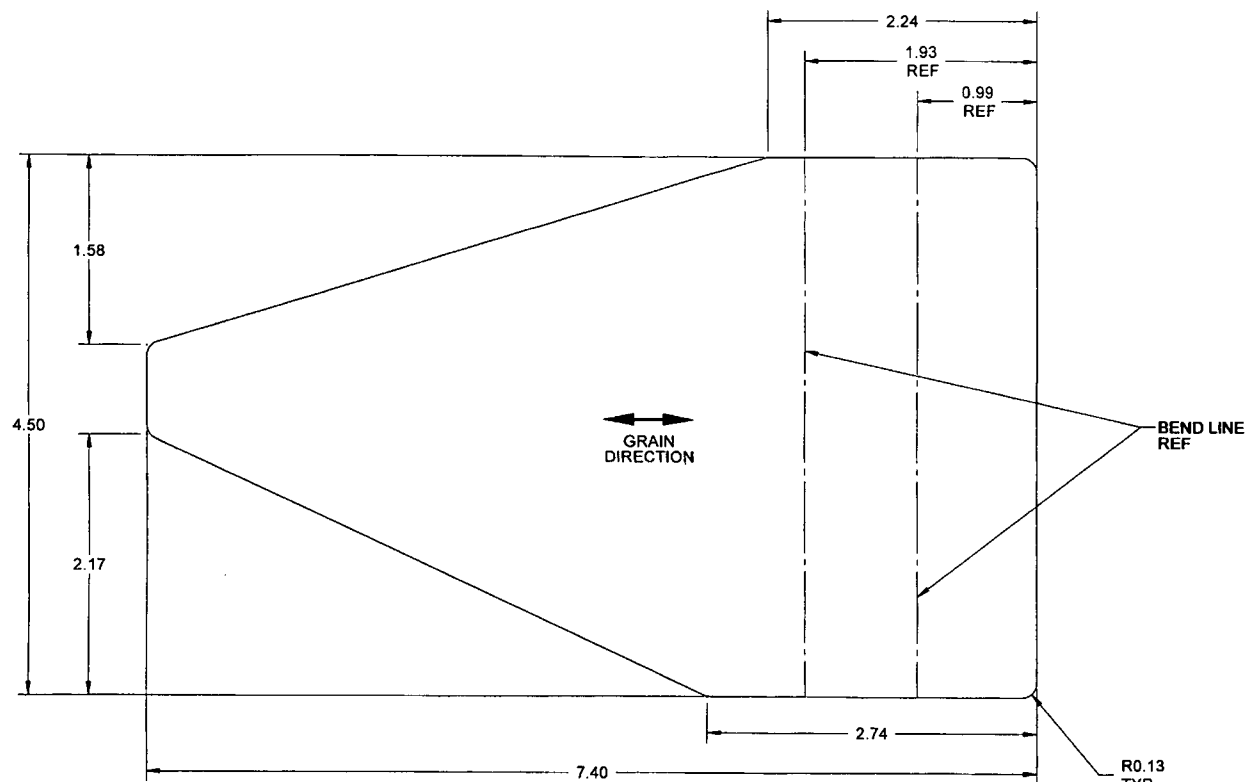
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NO. 52937

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NOTES:

- 1) MATERIAL: MADE FROM D3992-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>E</i>	D3992	SHEET 5 OF 6
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D3992-3F REINFORCEMENT FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
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MFG. APPR.	<i>BE</i>	D3992	SHEET 6 OF 6
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